

Date: Wednesday, 05/12/2007 3:44:48 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DUCT
Job Number : 36162	
Estimate Number : 12175	
P.O. Number : <i>N/A</i>	Part Number : D34761
This Issue : 05/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3476 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34396	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/12/2007 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 06-02-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.4374 sf(s)/Unit Total : 4.3743 sf(s)
304/316 0.018 SHEET
Batch: *105591* *B 07-12-5*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
Cut as per Dwg D3476
Dwg Rev: *A*
Prog Rev: *A*

B 07-12-5

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 07-12-5

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

2/12/06

(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Roll as per Dwg D3476

3-Spot weld as per Dwg D3476 and Dart QSI 018

mf

07-12-10

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/12/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 36162

Part Number: D34761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/12/10

10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/12/10

10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 103

Ca 2/12/11 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/12/10 (10)

Job Completion



u 07/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

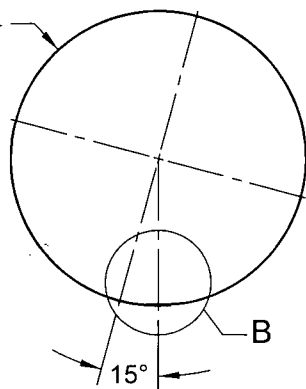
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

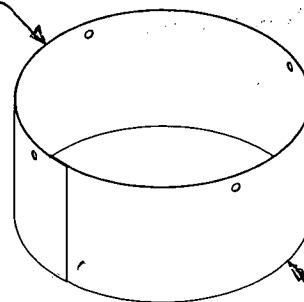
PRELIMINARY ISSUE
07.12.04

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 3 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER SCALE 1:4	

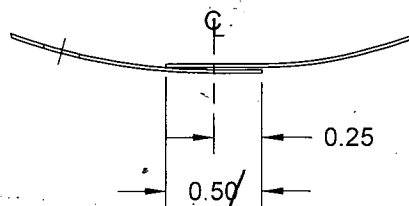
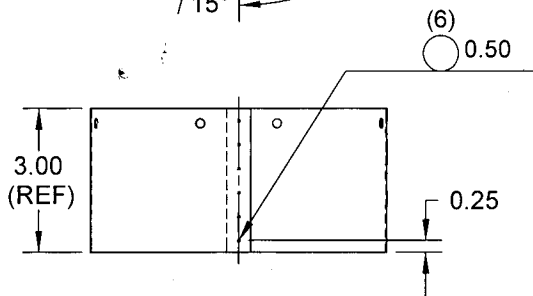
FORM TO FIT
AS SHOWN
IN ISOMETRIC
VIEW.



FORM Ø TO
FIT 26D71
BLOWER MOTOR.

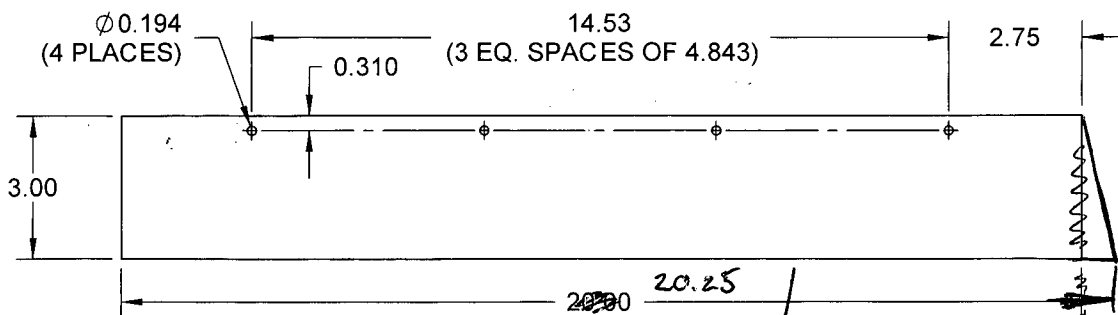


FORM Ø TO FIT
D3476-3 DOME



DETAIL B
SCALE 1:1

D3476-1 DUCT



D3476-1F DUCT FLAT PATTERN

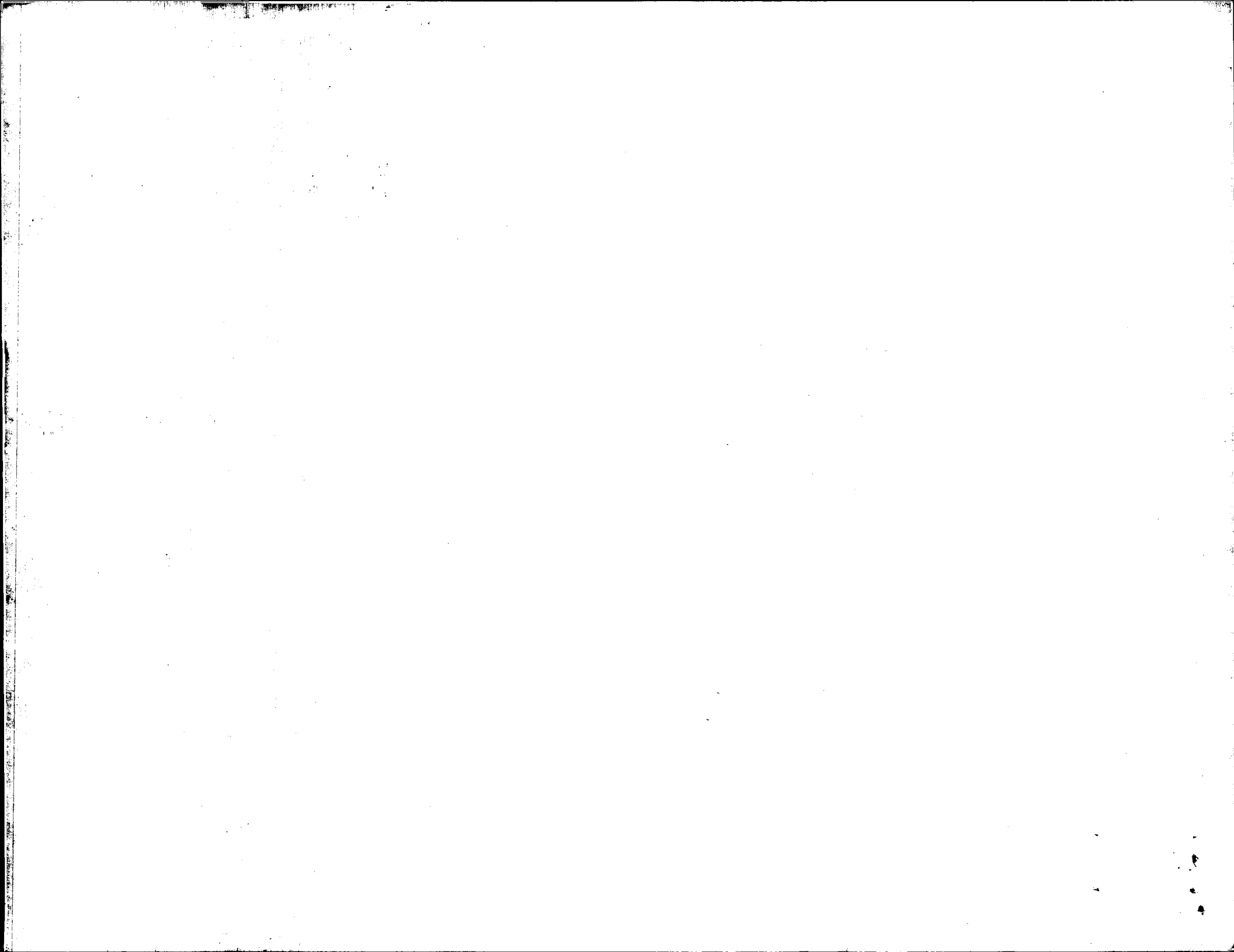
NOTES:

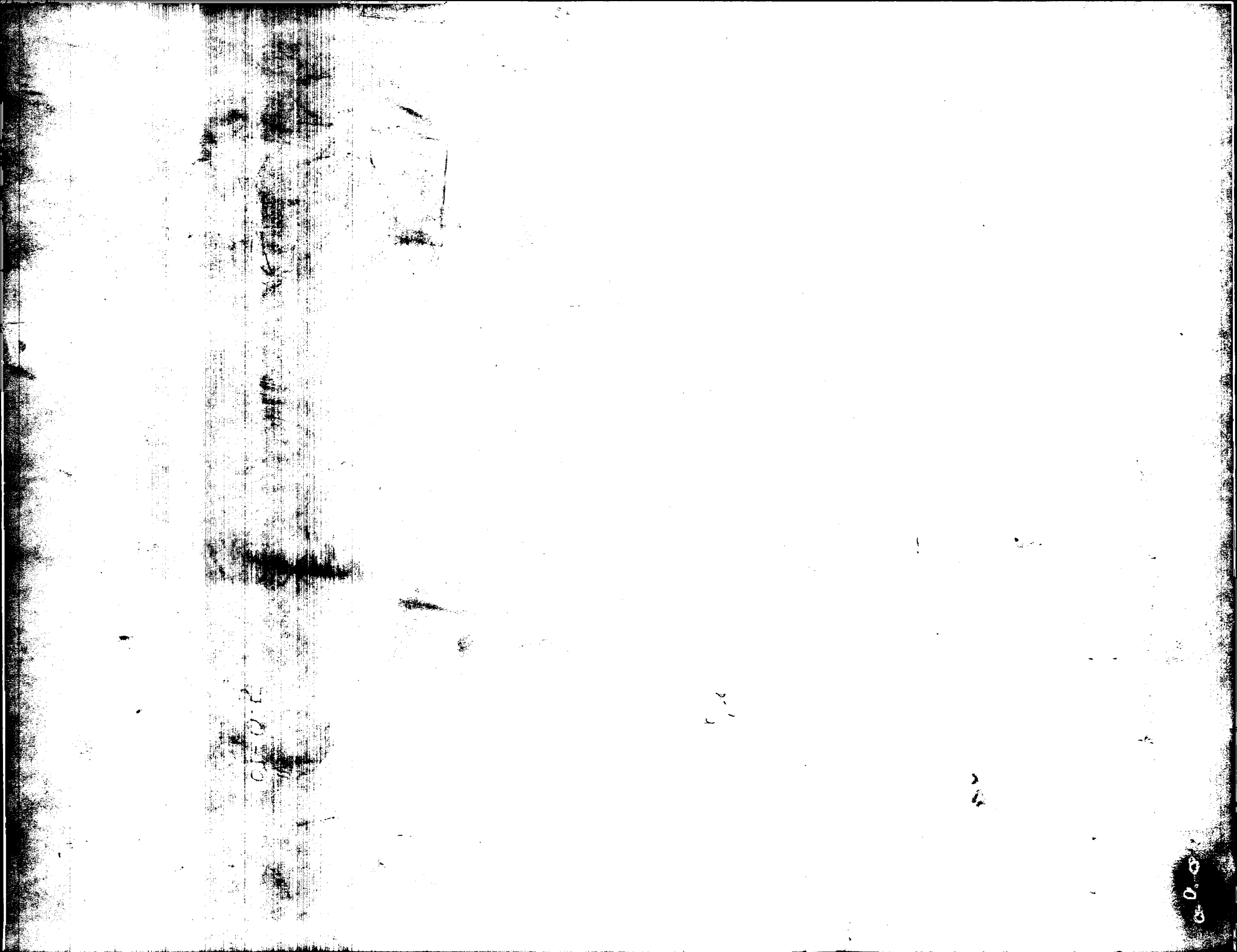
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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34604 x 9
34396 x 5





SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 42

EMPLOYEE: Melani Fawcett

PART NUMBER: D 3476-1

JOB NUMBER: B 36162

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.05

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/12/10
QUALIFIER: SB

